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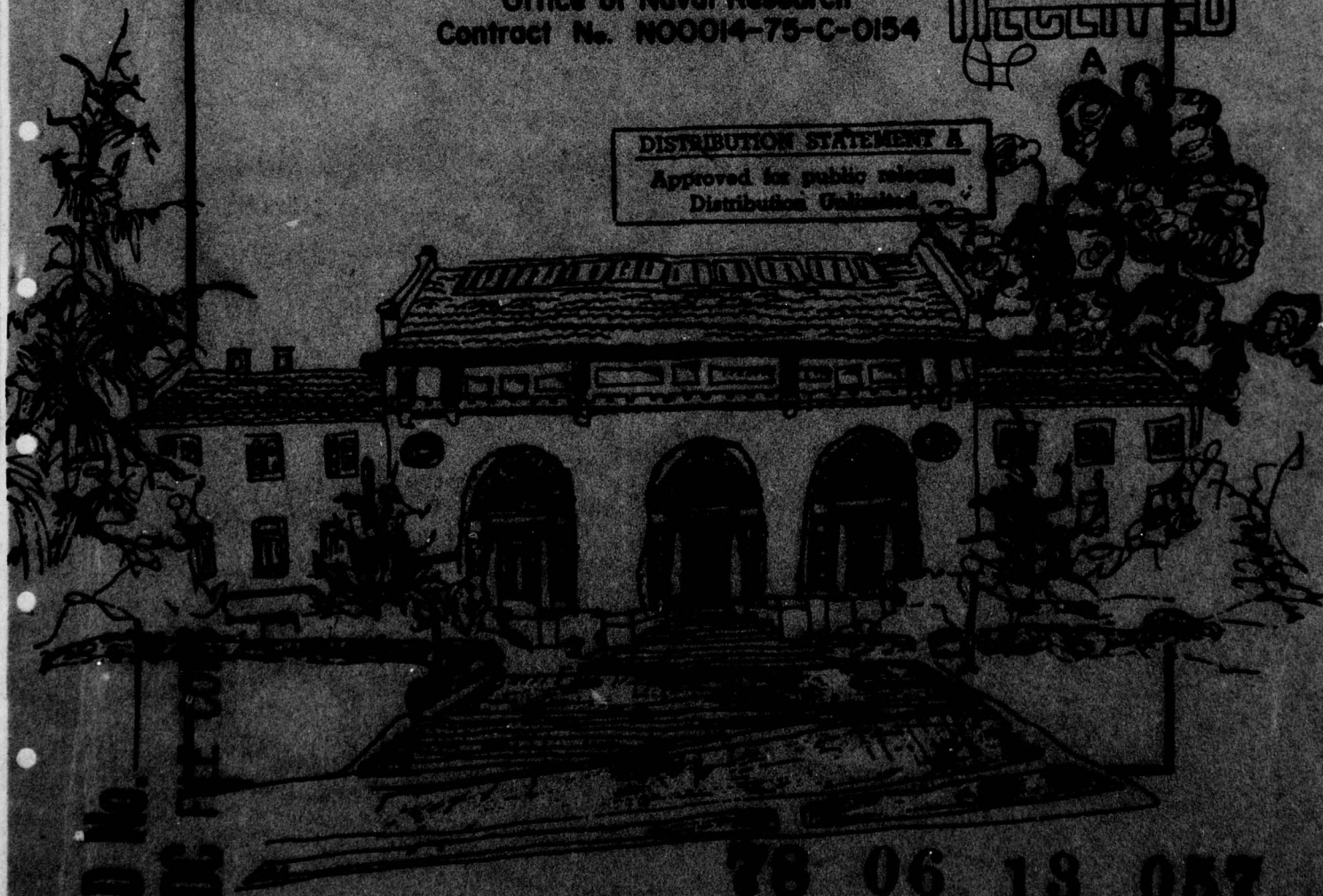
Department of Materials Science and Mineral Engineering
University of California, Berkeley

Technical Report No. 7
Office of Naval Research
Contract No. N00014-75-C-0154

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MECHANICAL STABILITY OF RETAINED AUSTENITE IN TEMPERED 9Ni STEEL

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ABSTRACT

↪ The behavior of the thermally stable austenite in the ductile fracture surface layer of a grain-refined and tempered 9Ni steel broken at 77°K was studied through use of ⁵⁷Fe Mossbauer spectroscopy and transmission electron microscopy. Thin foils revealing the microstructural profile of the fracture surface layer were prepared by electroplating a thick pure iron layer on the fresh fracture surface, then thinning a profile sample through a combination of conventional twin-jet electropolishing and ion milling techniques. The results of both ⁵⁷Fe Mossbauer spectroscopy and TEM studies showed that the thermally stable austenite transforms to a dislocated martensite in the deformed zone adjacent to the ductile fracture surface. This result suggests that transformation of the retained austenite present in tempered 9Ni steel is compatible with low temperature toughness, at least when the transformation product is a ductile martensite. ↪

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INTRODUCTION

Properly tempered Fe-(5-9)Ni¹⁻³ steels for cryogenic use contain a small admixture of retained austenite (5-10% by volume) which is believed to contribute to good low temperature toughness. The retained austenite forms as small elongated particles along martensite lath boundaries and prior austenite grain boundaries, as illustrated in Figure 1. If introduced by tempering in the lower portion of the two-phase ($\alpha + \gamma$) region of the equilibrium phase diagram, at temperatures in the range 500-600°C, the austenite is thermally stable and does not transform to martensite when cooled to liquid nitrogen temperature (77°K).

While it is widely accepted that precipitated and retained austenite has a beneficial effect on cryogenic mechanical properties the source of the effect is not well understood. Plausible explanations have been based both on the chemical properties of the austenite^{3,4}, in that it may "getter" potentially embrittling species, and on its low temperature mechanical properties¹⁻⁵ in that austenite is a relatively ductile phase which may enhance local ductility or blunt propagating fractures. Either explanation is, however, complicated by the question of the mechanical stability of the austenite; while the austenite is thermally stable it may nonetheless undergo catastrophic transformation to martensite in the intense deformation field near the tip of a propagating crack.

Research in recent years has particularly emphasized the importance of the mechanical stability of retained austenite to the low temperature toughness of Fe-Ni cryogenic steels. It was noted some time ago that the beneficial effect of retained austenite formed during tempering decreases dramatically as the tempering temperature is raised above ~575°C, a result which has been attributed⁶ to a decreasing mechanical stability of the austenite due to lower nickel content at higher temperatures of formation. More direct evidence

for a causal connection between austenite instability and low temperature embrittlement was obtained by Kron et al ⁷ who conducted an extensive fractographic analysis of 9Ni steel samples fractured below the ductile-to-brittle transition temperature. They observed an apparent promotion of brittle fracture by cleaved particles in the fracture surface which appeared to be transformed austenite. The evidence led Nagashima, et al ¹ to list mechanical stability of retained austenite as a major metallurgical requirement in their successful development of a 6Ni cryogenic steel. Their reasoning appeared to be confirmed by the corollary metallographic studies of Haga ⁸ who artificially introduced brittle fracture into a 6Ni steel sample at 77°K and successfully prepared a profile TEM fractographic specimen of the broken surface. His transmission electron microscopic studies show the retention of austenite to within a few microns of the fracture surface. Apparent austenite transformation to a twinned martensite is occasionally observed, suggesting that the specimen would have been brittle had more extensive transformation taken place.

The conclusion that retained austenite must be stable to impart low temperature toughness is, however, seriously called into question by results obtained during the last two years. Using Mössbauer spectroscopy to perform quantitative analysis of the residual phases present in fracture surfaces both Kim and Schwartz ⁹ and Fultz ¹⁰ found essentially complete transformation of retained austenite near the ductile fracture surface of 9Ni steel specimens broken above the ductile-brittle transition temperature. The Mössbauer evidence is not definitive, since it cannot distinguish a transformation which occurred during fracture from one which happened after the fracture was complete. However, this evidence does suggest both a counterexample to the conclusion that austenite must be mechanically stable in cryogenic steels and

a puzzle, since it is not clear how the fracture could remain ductile in the presence of the brittle transformation products found by Kron et al⁷ and by Haga.⁸

To clarify the issues raised by the Mössbauer evidence cited above we undertook a transmission electron microscopic study of the structure near the ductile fracture surface of a tempered 9Ni steel specimen broken at liquid nitrogen temperature. The direct observation of the structure immediately adjacent to the fracture surface required the preparation of profile fractographic specimens for TEM, i.e., foils containing the fracture surface which are sufficiently thin for transmission studies. To our best knowledge no such studies have previously been made on a ductile fracture surface in a high strength steel; hence a major part of this work involved the development of sample preparation techniques.

EXPERIMENTAL

A 9Ni steel plate of 30mm thickness was supplied by the Nippon Steel Corporation. Its chemical composition is given in Table I. Compact tension fracture toughness specimens were cut out of the plate. To insure that these specimens would fail in a ductile manner at 77°K the as-received microstructure was erased by annealing at 900°C for two hours, and the specimens were given the grain refinement treatment shown in Figure 2. After grain refinement the specimens were tempered at 575°C for one hour and water quenched. The final microstructure of the specimens is illustrated in Figure 1. Previous work¹¹ has shown that this grain refinement plus tempering treatment suffices to reduce the ductile-to-brittle transition temperature of 9Ni steel to below 6°K. Fracture toughness tests were conducted on these specimens in liquid nitrogen (77°K) with the result that the specimens failed in a ductile manner (Figure 3) with a fracture toughness (K_{IC}) estimated to exceed 300 ksi \sqrt{in} (330 MPa \sqrt{m}), in agreement with earlier results.

One of the two matching parts of a specimen fractured at 77°K was used for Mössbauer spectroscopy. The fracture surface of the other piece was electroplated with pure iron to a thickness of more than 2mm using the Fischer-Langbein type solution.¹² The plated piece was sliced along the direction of the fracture crack propagation and perpendicular to the fracture surface. Three slices, ~500µm thick, were chemically and mechanically thinned to a thickness of ~40µm. Discs of 3mm diameter were then spark cut from the slices in such a way that the boundary lines between the plated iron layer and the fractured 9Ni steel lay approximately along a diameter of the disc (Figure 4).

The radius of the plastic zone in these fractured 9Ni samples was estimated to be ~2.5mm¹¹, an estimate which is consistent with the observations of the fracture surface reported below. The 3mm discs hence contained undeformed electroplated iron in intimate contact with severely deformed 9Ni steel of complex microstructure, posing a sample thinning problem of particular severity. TEM specimens were successfully prepared in a two-step process. First, each disc was electropolished using the familiar twin-jet method until a small hole was formed at the center. The area around the hole was then further thinned by ion milling. After ion milling the 9Ni steel side of the disc was found to be slightly etched. The area around the hole was, however, thinned sufficiently for observation in a high voltage microscope operated at 650 KeV, and was sufficiently uniform to permit detailed studies of the microstructure immediately adjacent to the fracture surface.

Mössbauer analysis was carried out with a spectrometer which contained an Austin Science Associates velocity drive synchronized to a Packard 400 multichannel analyzer. The detector was of the Spijkerman type¹³ operated for backscatter electron detection. Conversion electrons originating within ~0.1µm of the surface were counted. Distinct spectral lines were observed and

the volume fraction of austenite was determined from the seven peak approximation.¹⁴ By sequentially analyzing the fracture surface and the undeformed specimen surface well away from the fracture surface the comparative changes in the fracture surface could be directly determined. The fracture surface was electropolished for further analysis to determine the variation of austenite volume fraction with depth.

RESULTS

(a) Mössbauer Spectroscopy

The results of the Mössbauer analysis are presented schematically in Figure 5. The undeformed specimen surface shows a clear austenite peak corresponding to a retained austenite content of $\sim 7\%$ by volume. This peak is absent in the spectrum obtained from the fracture surface suggesting an essentially complete transformation of the austenite over the region (to $\sim 0.1\mu\text{m}$ below the fracture surface) from which the data is taken. The austenite peak was also absent from the spectrum taken from the fracture surface after electrolytic etching to a depth of $\sim 1\text{mm}$. This result suggests a general transformation within the plastic zone associated with the fracture, whose radius is estimated to be 2.5mm for this particular case.

(b) Transmission Electron Microscopy

The profile fractographic samples prepared for this study permitted examination of the region below the fracture surface to a depth of $\sim 20\mu\text{m}$ in a transmission electron microscope operated at 650 KeV . Typical bright field micrographs are shown in Figures 6 and 7. The fracture surface is easily located by the abrupt change in microstructure between the electroplated iron layer (above) and the deformed 9Ni steel (below) and is marked with arrows and a dashed line respectively. The severe deformation of the alloy immediately below the fracture surface is visually apparent. Figure 6 includes a selected area diffraction

pattern taken from the central region of the micrograph immediately below the fracture surface. The spread of the diffraction spots along each diffraction ring is indicative of the severe deformation of the subsurface material; as shown in Figure 1 the selected area diffraction from the undeformed material yields a well-defined spot pattern. No extra spots attributable to retained austenite are present in the diffraction pattern.

A careful survey of the deformed region below the fracture surface to a depth of $\sim 20\mu\text{m}$ yielded no diffraction evidence for retained austenite, despite the fact that features which morphologically resemble the retained austenite present in the undeformed alloy are common. Examples of γ -like features are circled in Figures 6 and 7; they are comparable to the retained austenite particles present in the dark field micrograph in Figure 1. The TEM study hence supports the conclusion from Mössbauer analysis that there is complete transformation of the austenite near the fracture surface.

The TEM evidence argues, however, that the transformation of the austenite is in this case to a dislocated martensite rather than to a twinned martensite as suggested by earlier work.⁸ In a careful structural survey of the subsurface region no example of internally twinned martensite was found. In particular, the martensite particles which were tentatively identified as transformed austenite on morphological grounds were dislocated rather than twinned. Examples include the circled regions in Figure 6.

DISCUSSION

The evidence presented above appears to justify the conclusion that the retained austenite present in this grain-refined 9Ni steel specimen transformed to a highly dislocated martensite in the plastic zone associated with ductile fracture at 77°K. The only alternative explanations of the data which suggest

themselves are that the fracture propagated through a region which was initially free of retained austenite or that the transformation to martensite occurred during relaxation of the free surface after fracture. Given the uniform distribution of retained austenite in the initial specimens, the depth of the zone denuded of austenite beneath the fracture surface, and the observation of significant austenite content near other free surfaces of the specimen, neither of these alternative explanations seems plausible.

Transformation of the retained austenite to a dislocated martensite is not inconsistent with good low temperature toughness, and would, in fact, be expected to favor ductile fracture. The austenite formed on tempering at 575°C is expected to be high in nickel relative to the base alloy; a nickel content near 20 atomic percent is estimated from the equilibrium phase diagram. Moreover, the austenite forms micron-sized particles in the lath boundaries of the parent martensite. The product of the strain induced transformation of this austenite, a high-nickel dislocated martensite of sub-micron size, should be even more ductile than the surrounding matrix and should not introduce preferential sites for cleavage fracture. On the contrary, the presence of this transformed austenite should inhibit brittle fracture in the plastic zone near the crack tip by preventing inter-lath fracture and interfering with the cooperative cleavage of adjacent laths. Moreover, by Le Chatelier's principle, the transformation strain associated with the martensitic transformation of the retained austenite will tend to relax the fracture stress, hence further promoting ductile failure.

It is not entirely clear how the previous results of Haga⁸ and of Kron et al⁷ may be reconciled with the results presented here. Further investigations are in progress in this laboratory. However, it is almost certainly relevant that both investigations considered the behavior of retained austenite during

essentially brittle fracture. In Haga's case the presence of retained austenite near the fracture surface may simply reflect the narrow zone of deformation near the brittle fracture surface he obtained. The twinned martensite particles appearing in his micrograph may result from the difference in the composition of his alloy, from thermally-induced partial transformation of the austenite, from transformation near the free surface after fracture¹⁵, or from a change in the mode of austenite transformation due the high rate of brittle crack propagation. The results of Kron et al⁷ are ambiguous since it has not been conclusively shown that the cleavage features they observed are due to the mechanically-induced transformation of austenite. If their interpretation of their data is correct their evidence indicates that the low temperature fracture behavior of 9Ni steel is sensitive to the mechanical properties (and hence to the microstructure) of the martensitic product of the strain-induced transformation of retained austenite, a result which is not inconsistent with the observations reported here.

CONCLUSIONS

Both Mössbauer spectroscopy and direct transmission electron microscopic study show that the thermally-stable austenite introduced on tempering a grain-refined 9Ni steel at 575°C transforms to martensite in the deformed zone associated with ductile fracture at 77°K. The TEM evidence indicates that the transformation product is a sub-micron sized dislocated martensite which does not embrittle the alloy and may act to promote low temperature toughness. These results argue that it is not necessary that the austenite introduced on tempering ferritic Fe-Ni cryogenic steels be mechanically stable to promote low temperature toughness. A sufficient requirement is that the austenite transform to a ductile martensite during fracture.

A corollary result of this work is the demonstration that it is practical to make profile fractographic samples for transmission electron microscopic study of ductile fracture in steel. This technique should have wide application in cases where local microstructural effects are believed to be relevant to the fracture process.

ACKNOWLEDGEMENT

The authors are grateful to the Nippon Steel Corporation for research materials, and are especially grateful to Dr. Shin-ichi Nagashima and Mr. Hiroshi Sakurai of the Fundamental Research Laboratories of Nippon Steel for helpful discussions on the preparation of fractographic samples. This research was supported by the Office of Naval Research under contract #N00014-75-C-0154 and made use of the facilities of the Materials and Molecular Research Division of the Lawrence Berkeley Laboratory through the support of the Basic Energy Sciences Division of the Department of Energy.

TABLE I

CHEMICAL COMPOSITION (in weight %)

<u>C</u>	<u>Si</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Ni</u>	<u>Fe</u>
0.06	0.20	0.56	0.004	0.004	9.25	balance

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FIGURE CAPTIONS

- FIG. 1. Transmission electron micrographs of retaining austenite in grain refined and tempered 9Ni steel. (a) bright field, (b) dark field taken from $(002)_{\gamma}$ diffraction spot in (c).
- FIG. 2. Thermal cycling and temper procedure for grain refinement in 9Ni steel.
- FIG. 3. Scanning electron microscopic (SEM) fractograph. Tempered ($575^{\circ}\text{C}/1$ hour/water quench) after grain-refinement and fractured in the compact tension test at 77K. K_{IC} estimated to be $300 \text{ ksi}\sqrt{\text{in}}$ ($330 \text{ MPa}\sqrt{\text{m}}$).
- FIG. 4. Schematic diagram of disc preparation from the boundary area between the fractured 9Ni steel and the electroplated iron layer.
- FIG. 5. Conversion electron Mössbauer spectra from the fracture surfaces. Solid curves were hand-drawn through datum points.
- FIG. 6. Transmission electron micrograph and diffraction pattern of the fracture surface layer. The boundary between the electroplated iron layer (above) and fractured 9Ni steel (below) was marked by a dashed line. The diffraction pattern was taken from the central region right below the boundary line. The circled area shows retained austenite-like particles.
- FIG. 7. Another TEM picture of the fracture surface layer (the boundary indicated by arrows). The circled areas show retained austenite-like particles.

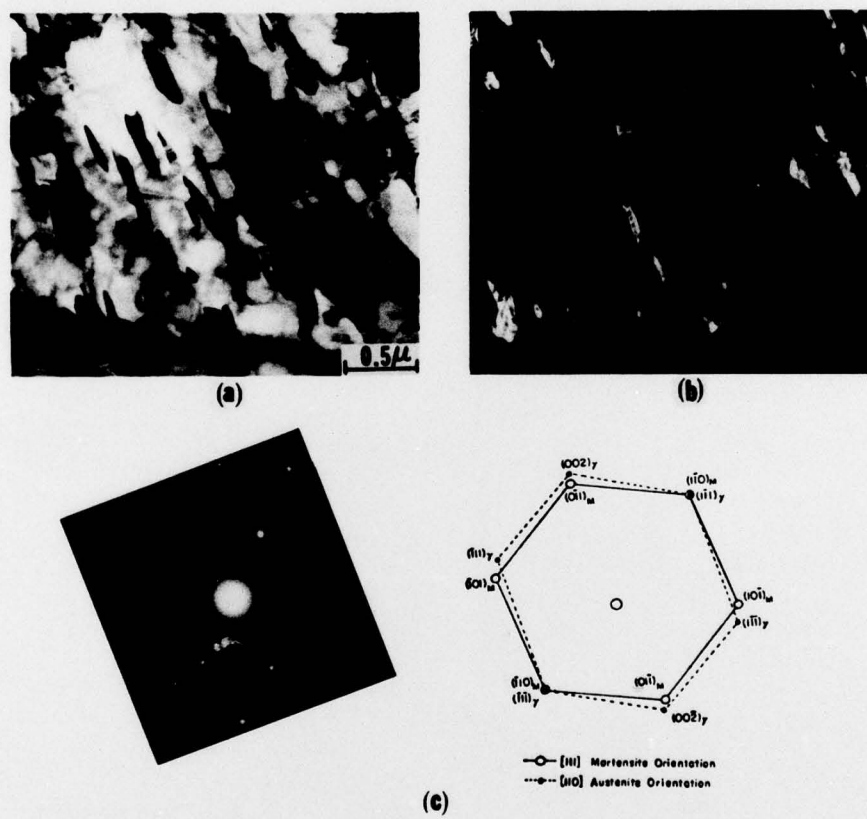
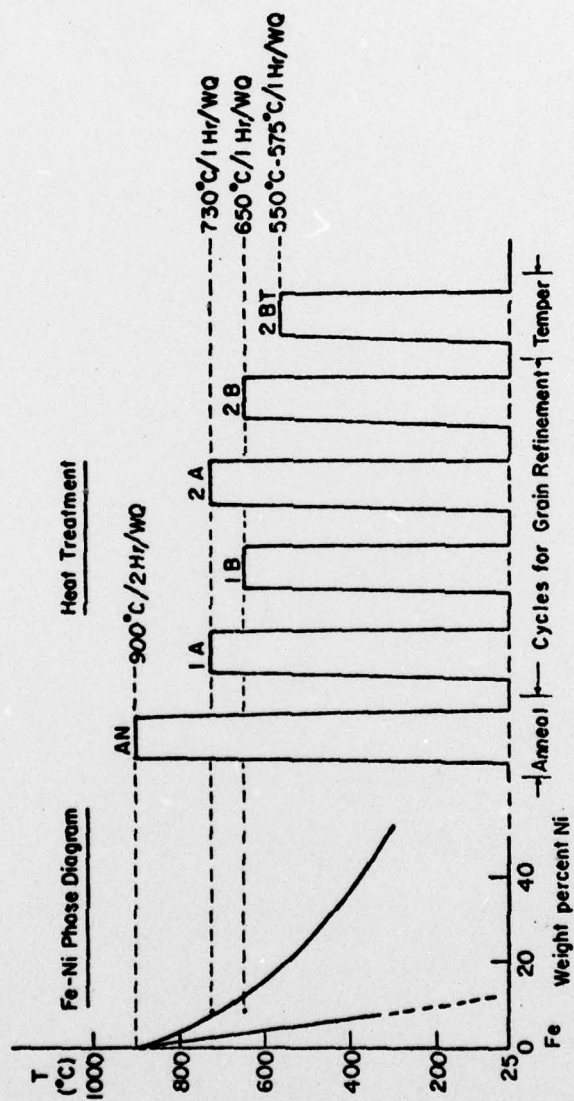


FIG. 1



XBL 762-6382

FIG. 2

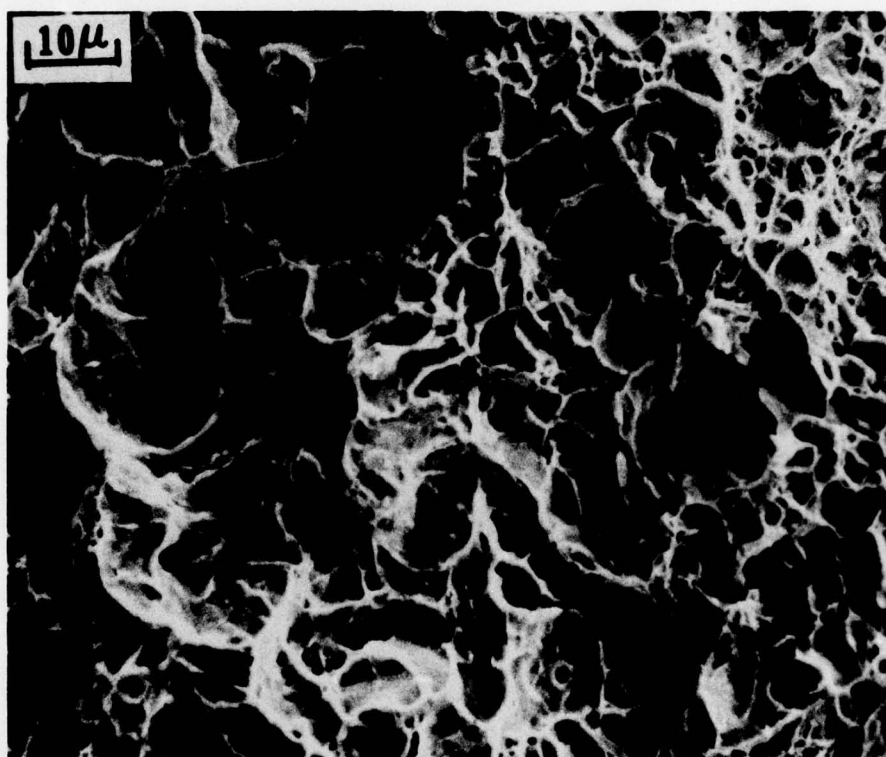
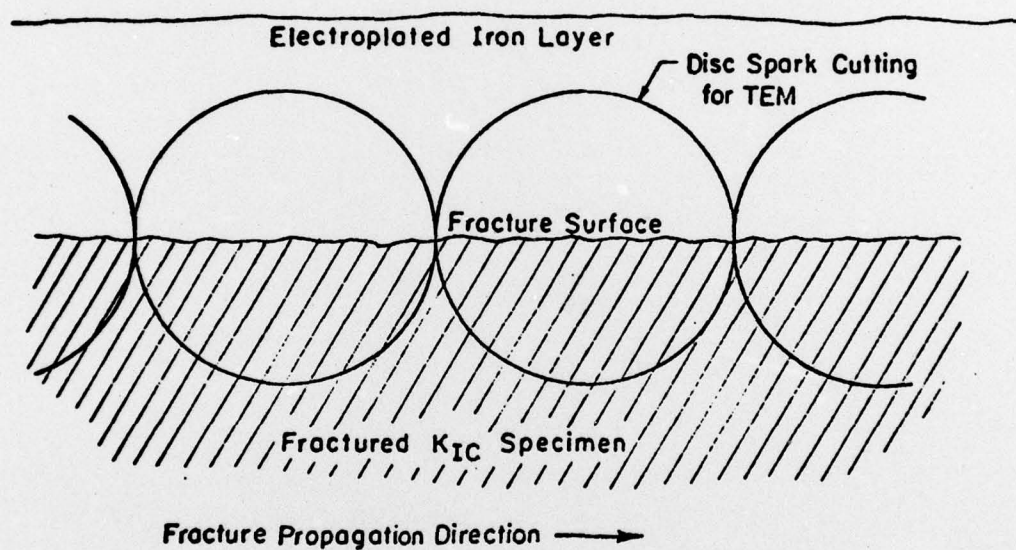


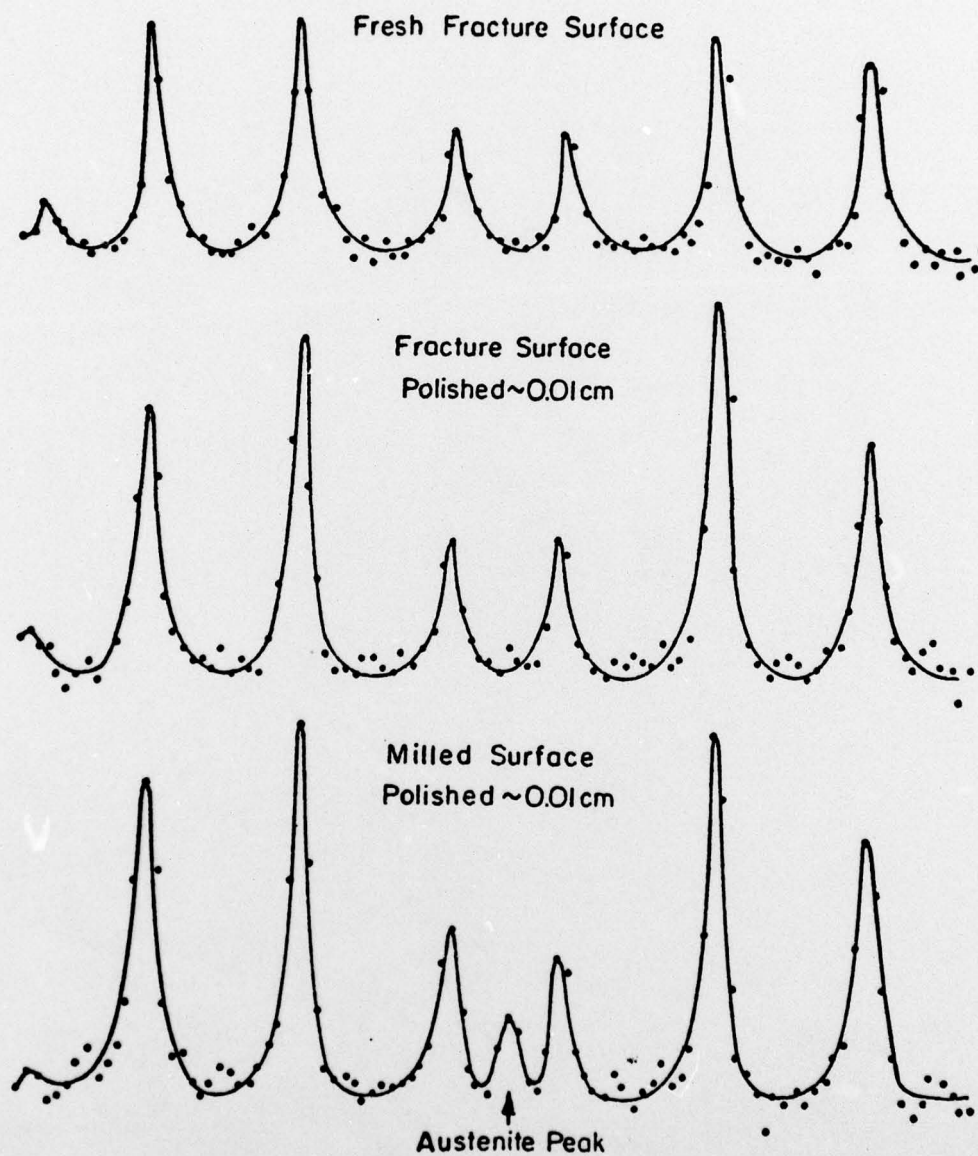
FIG. 3



XBL 7712-6566

FIG. 4

MÖSSBAUER SPECTRA FROM GRAIN-REFINED SPECIMEN BROKEN AT 77°K



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FIG. 5



FIG. 6



FIG. 7

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1. REPORT NUMBER No. 7	GOVT ACCESSION NO. (14) TR-7	3. RECIPIENT'S CATALOG NUMBER
2. TITLE (and Subtitle) (6) Mechanical Stability of Retained Austenite in Tempered 9Ni Steel.		5. TYPE OF REPORT & PERIOD COVERED (9) Technical Report, March 1978
7. AUTHOR(s) (10) C. K./Syn, B./Fultz J. W./Morris, Jr		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS University of California Berkeley, California 94720		8. CONTRACT OR GRANT NUMBER(s) (13) N00014-75-C-0154
11. CONTROLLING OFFICE NAME AND ADDRESS Office of Naval Research		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS 122201
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office) (12) 23 p.		12. REPORT DATE (11) March 1978
16. DISTRIBUTION STATEMENT (of this Report) Approved for public release; distribution unlimited		13. NUMBER OF PAGES 18
17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		15. SECURITY CLASS. (of this report)
18. SUPPLEMENTARY NOTES		15a. DECLASSIFICATION/DOWNGRADING SCHEDULE
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Steel; 9Ni steel; cryogenic steel; retained austenite; Mössbauer spectroscopy; fracture; transmission electron microscopy (TEM);		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) The behavior of the thermally stable austenite in the ductile fracture surface layer of a grain-refined and tempered 9Ni steel broken at 77°K was studied through use of Mössbauer spectroscopy and transmission electron microscopy. Thin foils revealing the microstructural profile of the fracture surface layer were prepared by electroplating a thick pure iron layer on the fresh fracture surface, then thinning a profile sample through a combination of conventional twin-jet electropolishing and ion milling techniques. The		

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